



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4113-041
Job Sheet 185437



Part No: D4113-041

Job Qty: 1 ea

Part Name: Doubler Assembly, Baggage Door



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/26/18

Job Tracking No:

Due Date: 10/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP rev:A 10.09.24 new issue DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	1 pcs		10/31/18	0.00	0.09	Waterjet - Flow		SC 18/10/29
110	QC	1 pcs		10/31/18	0.00	0.00	QC2 Waterjet-3		SC 18/10/29
120	QC	1 pcs		10/31/18	0.00	0.00	QC8-4		DAS 36-88
130	Small Fab	1 pcs		10/31/18	0.00	0.25	Small Fab-5		DAS 36-88
140	QC	1 pcs		10/31/18	0.00	0.00	QC5		FEB 2 6 2019 68
150	Packaging	1 pcs		10/31/18	0.00	0.00	Packaging3 51078 80		FEB 2 6 2019-89
160	QC21-SA	1 Ea		10/31/18	0.00	0.00	QC21		FEB 2 6 2019

Part Op 100 - 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - 1- C'sink doubler as per dwg 2- Bend doubler as per dwg 3- Install anchor nut, washer and ball stud as per dwg

140 - QC5- Inspect part completeness to step on W/O

150 - Identify as per dwg & Stock Location: _____

160 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.1434 sf (.1434 ea)	100-Waterjet	5106178
D3622-1	Ball Stud	1 Ea (1 ea)	130-Small Fab	5136653
MS20426AD4-5	Rivet	2 Ea (2 ea)	130-Small Fab	5083538-1
MS21069-5	Anchor Nuts	1 Ea (1 ea)	130-Small Fab	5147392
NAS1149C0563R	Washer	2 Ea (2 ea)	130-Small Fab	5060989

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M304S16GA	0	216	0
130-Small Fab	D3622-1	1	7	0
	MS20426AD4-5	2	1,922	0
	MS21069-5	1	36	0
	NAS1149C0563R	2	148	0

Part Specifications

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																							
Date : _____	Step #: _____	2) Approval _____ ed By _____ Supervisor _____ ification _____ ordinator _____ al _____																																																																																																							
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<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="4" style="text-align: left;">Root Cause</th> </tr> </thead> <tbody> <tr> <td style="width:15%;">Environment</td> <td style="width:15%;">☐</td> <td style="width:15%;">No Re-verification</td> <td style="width:15%;">☐</td> <td style="width:15%;">Pressure/Forced</td> <td style="width:15%;">☐</td> <td style="width:15%;">Wrong</td> <td style="width:15%;">☐</td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Operator</td> <td>☐</td> <td>Bending</td> <td>☐</td> <td>ensions</td> <td>☐</td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Offset/Setup</td> <td>☐</td> <td>Centre Not Conce</td> <td>☐</td> <td>very, under tolerance</td> <td>☐</td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supplier</td> <td>☐</td> <td>Cracks</td> <td>☐</td> <td>Part Incorrect</td> <td>☐</td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Training</td> <td>☐</td> <td>Crimp/Kink/Ripple/Wave</td> <td>☐</td> <td>Part Lost/Missing</td> <td>☐</td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Testing</td> <td>☐</td> <td>Cuffs</td> <td>☐</td> <td>Part Moved</td> <td>☐</td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> <td>Crushing</td> <td>☐</td> <td>Drawing</td> <td>☐</td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐</td> <td>Heat Treat</td> <td>☐</td> <td>Finish</td> <td>☐</td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> <td>Wave/Twist in Tube</td> <td>☐</td> <td>Misread</td> <td>☐</td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> <td>Marks/Chatter</td> <td>☐</td> <td>Turning Sequence</td> <td>☐</td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐</td> <td></td> <td>☐</td> <td></td> <td></td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐</td> <td>OTHER :</td> <td>☐</td> <td></td> <td></td> </tr> </tbody> </table>						Root Cause				Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Wrong	☐	Design	☐	Operator	☐	Bending	☐	ensions	☐	Doc/Data	☐	Offset/Setup	☐	Centre Not Conce	☐	very, under tolerance	☐	Equip/Tooling	☐	Supplier	☐	Cracks	☐	Part Incorrect	☐	Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Part Lost/Missing	☐	Material	☐	Use for Testing	☐	Cuffs	☐	Part Moved	☐	Internal Transport	☐	Poor Information	☐	Crushing	☐	Drawing	☐	Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Finish	☐	LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Misread	☐	Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Turning Sequence	☐	Past Expiry Date	☐	Manufacturing Process	☐		☐			Misidentified	☐	Past Due	☐	OTHER :	☐		
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Container No: S122226
 Part: D413-041
 Job No: 185437
 Serial No/Batch: S122226
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: Various STC's
 Date: 10/29/18

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 www.dartaerospace.com

Specifications could not be found.

Plex 10/26/18 10:49 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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